

Work Order ID 80576

February-23-12 11:23:12 AM

80576

Page 1

Item ID: D3943-053

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Chain Assembly

Stop ***NS2***

Start Date: 23/02/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 08/03/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.C.J.

Date: 12/02/23 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3943

E

100 Weld per dwg A/R Steel rod Batch: M12357 0.00

100

Large Fab

Memo

0.00

Large Fab

ASSEMBLE WITH CHAIN BEFORE WELDING

④ Q 12-1-5

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

12-1-5



120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

0.00

Quality Control

12-1-5



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80576

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Page 2

February-23-12 11:23:12 AM

Item ID: D3943-053 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Chain Assembly
 Start Date: 23/02/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 08/03/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Hybrid safety Yellow 4.3.5.12 Memo 1- MASK CHAIN FROM THIS POINT ON PRIOR TO powdercoat AS PER DWG 2- POWDER COAT: 3:30 Start Time: _____ Oven Temperature: 400°F Finish Time: 4:00	0.00 0.00				4X ✓			mf 12/11/08
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4x ✓			12/11/09
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: w/o 91730 Memo	0.00 0.00				④			12-11-12

m116329

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Work Order ID 80576***80576***

Page 3

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Revision ID:

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Item Name: Chain Assembly

Start Date: 23/02/2012 Start Qty: 4.00

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Cust Item ID:

Required Date: 08/03/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/11/13

ME
12-14-12

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Picklist Print

February-23-12 11:23:18 AM

Page 1

Work Order ID: 80576

80576

Parent Item: D3943-053

D3943-053

Parent Item Name: Chain Assembly

Start Date: 23/02/2012

Required Date: 08/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: add DEO DD 09.11.18 verified by:JLM IPP Rev:B as
per dwg REV.C DD 10.02.22 verified by:EC IPP rev C 11.05.24 ECN
11-578 ec verified by:DD IPP REV:D 11.08.16 AS PER
REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3954-5		Manufactured	No			100	Each	5.0000	1	4			
D3954-5									**				
Chain Lug													
	84425 x 3												
	70224 x 1												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST075				5					
				71173				5					
D3954-9		Manufactured	No			100	Each	19.0000	1	4			
D3954-9									**				
GWT Chain Pin													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST075				19					
				71876				19					
D4405-1		Manufactured	No			100	Each	9.0000	1	4			
D4405-1									**				
Eye and Fork Swivel													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				9					
				70986				5					
				78913				4					

used on all mfg 12-10-12

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ITEM No.	QTY -041	QTY -051	QTY -053	PART NUMBER	DESCRIPTION	PREFERRED SUPPLIER
1	X			D3943-041	GROUND HANDLING CRANK ASSEMBLY	
5	1	X		D3943-051	HANDLE ASSEMBLY	
6	1		X	D3943-053	CHAIN ASSEMBLY	
11		1		D3943-1	HANDLE	M/F HANDLE FROM DIS-ASSEMBLED ITEM 39
12	1			D3943-3	HANDLE EXTENSION	
13		1		D3943-5	PLATE	
14		2		D3943-7	STUD	
15			1	D3943-9	CHAIN	USE CHAIN SUPPLIED WITH ITEM 39
16			1	D4405-1	EYE AND FORK SWIVEL	
21	1			D2690-4	LANYARD	
22	1			D3585-1	SET SCREW	
23	1			D3949-041	REMOVE BEFORE FLIGHT FLAG	
24			1	D3954-5	CHAIN LUG	
25	1			D3954-7	RATCHET LUG	
26			1	D3954-9	GWT CHAIN PIN	
31	1			AN5-11A	BOLT	
32	1			AN960-516	WASHER	
33	1			MS21042L5	NUT	
39	1			8143919	LEVER CHAIN HOIST (POWER FIST)	PRINCESS AUTO / 4000 lbs CAPACITY
51	1			S-1475	SPRING	REID SUPPLY
52	1			3408A59	BALL PLUNGER	McMASTER CARR
53	1			HX-15	SOCKET HEAD CAP SCREW 1/2-20 UNC X 0.75 LG	HASKINS
54	1			HX-16	SOCKET HEAD CAP SCREW 1/2-20 UNC X 1.0 LG	HASKINS

SHEET COPY
 RETURN TO
 ENGINEERING
 UNLESS OTHERWISE NOTED
 SEE ITEM 11-113
 WITHOUT NOTICE
 WORK ORDER

80576 M.C.J
 12/02/23

RELEASED
 2011-07-29

E	CHANGED D3945-3 MATL TO SS (B8-5); FINISH NOW "NONE" (A7-5); TAP DRILL FOR 1/4-20 UNF-2B WAS PILOT HOLE NOTE (B1-5). PER PAR11-113.	MB	11.07.27
D	SHT 1 PL. ITEMS 51-54 RENUMBERED SEE PREV. REV. FOR DETAILS, ITEM 16 ADDED (VIEWS UPDATED). SHT 2 ZN D3 FLAG RELOCATED. SHT 3 ZONE D3, Ø0.12 HOLE DELETED. (SEE NCR 11-495)	AJS	11.05.16
C	RMV FINISH -041 (ZN A8-2), ADD NEW FINISH -051/-053/-1/-3 (A8-3/-4/-5), ADD CALIBRATION (A8-2), (1) HX-16 WAS HX-15 (B3-1, C3-1). PAR 10-001	CP	10.01.26
B	SHT 1 PL. ITEM 31 WAS AN4-10A, ITEM 32 WAS AN960-416, ITEM 33 WAS MS21042-4, ITEM 43 WAS 0.75 LG. SHEETS 2 - 5 NOTES: FINISH FOR ALL COMPONENTS NOW YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DSTON / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D3943	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	GROSS WEIGHT TOW CRANK ASSY	NTS
DATE	11.07.27	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

REMOVE AND RETAIN
RUBBER HAND GRIP

DISCARD PIN

RETAIN PIN

REMOVE &
DISCARD HOOK

8143919 LEVER CHAIN HOIST
(SHOWN PRIOR TO MODIFICATION)
(CHAIN SHOWN SHORTENED FOR CLARITY)

AN5-11A BOLT
AN980-516 WASHER
MS21042L5 NUT

3408A59
BALL PLUNGER

8143919
LEVER CHAIN HOIST

(CHAIN NOT SHOWN FOR CLARITY)

RE-INSTALL
RUBBER HAND-GRIP
HERE

D3943-3
HANDLE EXTENSION

D2690-4 LANYARD

D3949-041 FLAG

HX-16 S/H CAP SCREW

HX-15 S/H CAP SCREW
S-1475 SPRING

CALIBRATION TAG

D3585-1 SET SCREW

RE-INSTALL PIN

D3943-053 CHAIN ASSY

(CHAIN SHOWN SHORTENED FOR CLARITY)

D3943-041 GROUND HANDLING CRANK ASSEMBLY

NOTES -041:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3943-041" USING FINE POINT PERMANENT INK MARKER
- 7) CALIBRATION TAG PER DART QSI 008 4.4 (ZN C1-2)

DESIGN	DSTO / AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D3943	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	GROSS WEIGHT TOW CRANK ASSY	NTS
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2011-07-29

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NOTE: Date & initial all entries

D3943-1 HANDLE

2 PL

9.75

2.00

Ø0.31
THRU

D3943-7 STUD
2 PL

THREAD $\frac{1}{4}$ -20 UNC-2B
THRU



VIEW A-A AS-3
(SCALE 2X) BS-3

9.38
REF

2 PL

A B1-3

D3943-5 PLATE

D3943-051 HANDLE ASSEMBLY

NOTES -051:

- 1) MATERIAL : N/A
- 2) FINISH: POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3
- 3) TOLERANCES: X.XX DIMENSIONS +/- 0.06 ALL OTHERS
PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) MASK ALL THREADS PRIOR TO FINISHING

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
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CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D3943	SHEET 3 OF 5
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DE APPR.	N/A	GROSS WEIGHT TOW CRANK ASSY	NTS
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RELEASED
2011-07-28

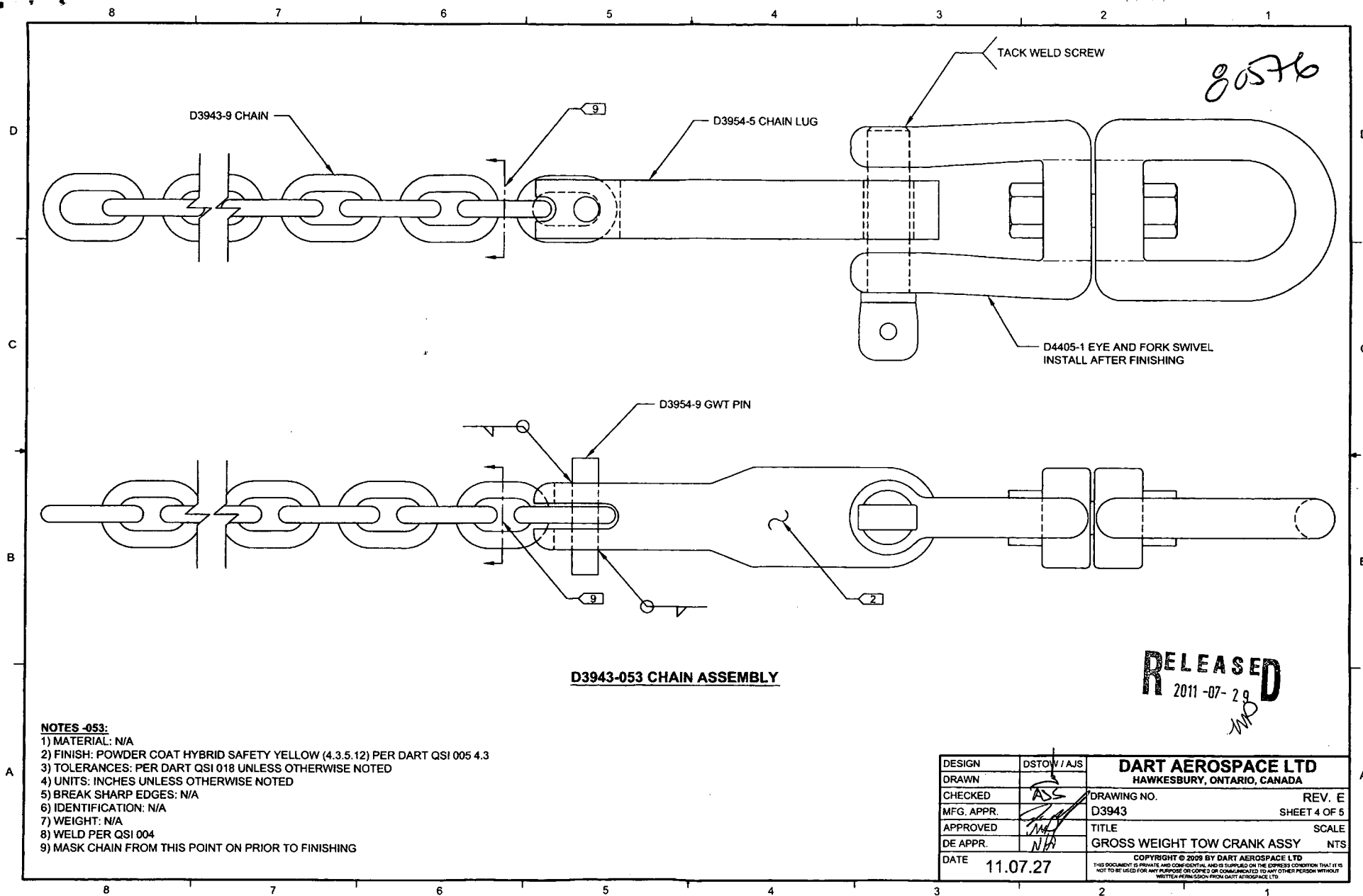
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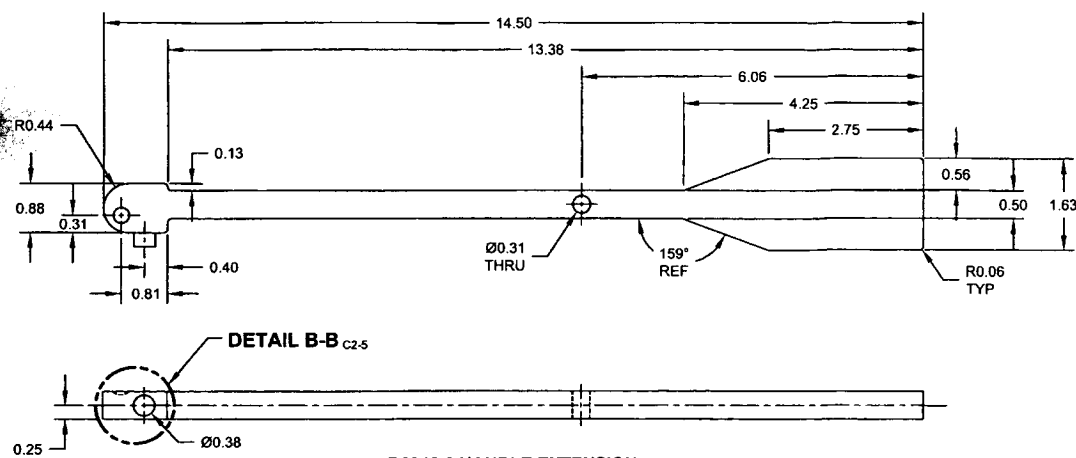
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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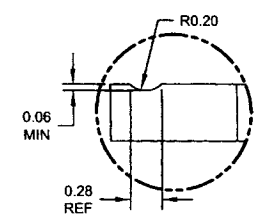
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

80576



DETAIL B-B C2-5



DETAIL B-B C7-5
(DIMPLE DETAIL)
(SCALE 2X)

D3943-3 HANDLE EXTENSION

NOTES:

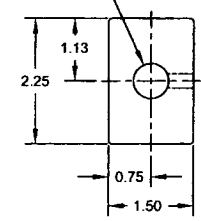
1) MATERIAL -3: AISI 304/316 STAINLESS STEEL SHEET
ANNEALED 2B FINISH PER MIL-S-5059
OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S
OR:
AISI 303 STAINLESS STEEL SHEET
ANNEALED 2B FINISH PER MIL-S-5059
ASTM A240 OR ASME SA240
REF DART SPEC M303S

-5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S
OR:
MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A366/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B

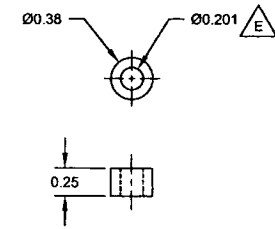
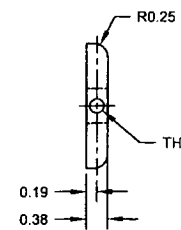
-7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A

THREAD 1/8-11 UNC-2B



D3943-5 PLATE



D3943-7 STUD
(SCALE 2X)

RELEASED
2011-07-28

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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APPROVED		TITLE	SCALE
DE APPR.		GROSS WEIGHT TOW CRANK ASSY	NTS
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8 7 6 5 4 3 2 1

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